

Work Order ID 83073

83073

Page 1

April-12-12 4:08:36 PM

Item ID: D2671

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw, 206 Narrow

Start Date: 12/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/04/13*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2671 | Rev B1 | | | | | | | | |
| 120 | | 0.00 | | | | | | | |
| *120* | FLOW WATER JET | | | | | | | | |
| Waterjet | Memo | 0.00 | | | | | | | |
| FLOW CNC Waterjet | Cut Blank as per File D2671_BLANK | | | | | | | | |
| <i>UHMW 1" Blk.</i> | | | | | | | | | |
| 130 | | 0.00 | | | | | | | |
| *130* | HAAS CNC VERTICAL MACHINING #1 | | | | | | | | |
| HAAS 1 | Memo | 0.00 | | | | | | | |
| HAAS CNC vertical machine #1 | 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA790 and Dwg D2671 Identify as D2671 3-Deburr | | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| *140* | QC2- Inspect parts off machine FAI/FAIB | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

6 0 12-4-20

PD/B. 12/04/27 6 0

PD/B. 12/04/27 6 0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location:

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

OK 12/04/30

PP 82904

(62)

12/11/30

12/5/12

MLJ 12/04/30

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NOTE: Date & initial all entries

Picklist Print

April-12-12 4:08:39 PM

Page 1

Work Order ID: 83073

83073

Parent Item: D2671

D2671

Parent Item Name: Bearpaw, 206 Narrow

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MUHMWB10 | | Purchased | No | | | 120 | sf | 404.5100 | 2.7 | 16.2 | | | |

MUHMWB10

UHMW 1" Black

**

| Location | Loc Qty | Loc Code |
|----------|-------------|----------|
| MAT018 | 83.00999474 | |
| 120401 | 0.00999474 | |
| 120972 | 3 | |
| 121346 | 80 | |
| MAT019 | 1.5 | |
| 118814 | 1.5 | |
| ST052 | 320 | |
| 121277 | 20 | |
| 121278 | 300 | |

121278

JM
12-4-20

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

| | | | |
|-----------------------|---------|--------------|-------|
| DART AEROSPACE LTD | | Work Order: | 83073 |
| Description: Bearpaw | | Part Number: | D2671 |
| Inspection Dwg: D2671 | Rev: B1 | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet | Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| A | 0.063 x 45° | +0.030/-0.010 | 0.063 x 45° | ✓ | | PHD-01 | VERN |
| B | 5.500 | +/-0.030 | 5.501 | ✓ | | " | " |
| C | 0.200 | +/-0.030 | 0.189 | ✓ | | PHD-09 | |
| D | R0.250 | +/-0.030 | 0.250 | ✓ | | Rad gauge | |
| E | 0.625 | +/-0.030 | 0.632 | ✓ | | PHD-01 | VERN |
| F | 0.250 | +/-0.010 | 0.246 | ✓ | | HB 120 | MIC |
| G | 0.950 | +0.030/-0.010 | 0.964 | ✓ | | PHD-01 | VERN |
| H | 0.25 x 45° | +/-0.030 | 0.250 x 45° | ✓ | | M TAPE | PHD-11 |
| I | 0.375 | +/-0.010 | 0.375 | ✓ | | HB 120 | MIC |
| J | 12.750 | +/-0.030 | 12.750 | ✓ | | PHD-11 | M TAPE |
| K | Ø0.260 | +0.005/-0.000 | 0.260 | ✓ | | Pin gauge | |
| L | Ø0.93 | +/-0.030 | 0.929 | ✓ | | PHD-01 | VERN |
| M | 0.30 | +0.030/-0.000 | 0.310 | ✓ | | PHD-09 | |
| N | 4.250 | +/-0.030 | 4.264 | ✓ | | PHD-01 | VERN |
| O | 0.375 | +/-0.030 | 0.379 | ✓ | | " | " |
| P | 2.000 | +/-0.030 | 2.002 | ✓ | | " | " |
| Q | 4.250 | +/-0.010 | 4.253 | ✓ | | " | " |
| R | 9.000 | +/-0.010 | 9.004 | ✓ | | " | " |
| S | 15.750 | +/-0.030 | 15.750 | ✓ | | PHD-11 | M TAPE |
| | | | | | | | |
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|--------------|----------|
| Measured by: | RJ/b-a |
| Date: | 12/04/27 |

| | |
|-------------|-------------|
| Audited by: | [Signature] |
| Date: | 12/04/30 |

| | |
|---------------------|-----|
| Prototype Approval: | N/A |
| Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|-------------|
| A | 03.09.22 | New Issue | KJ/RF | [Signature] |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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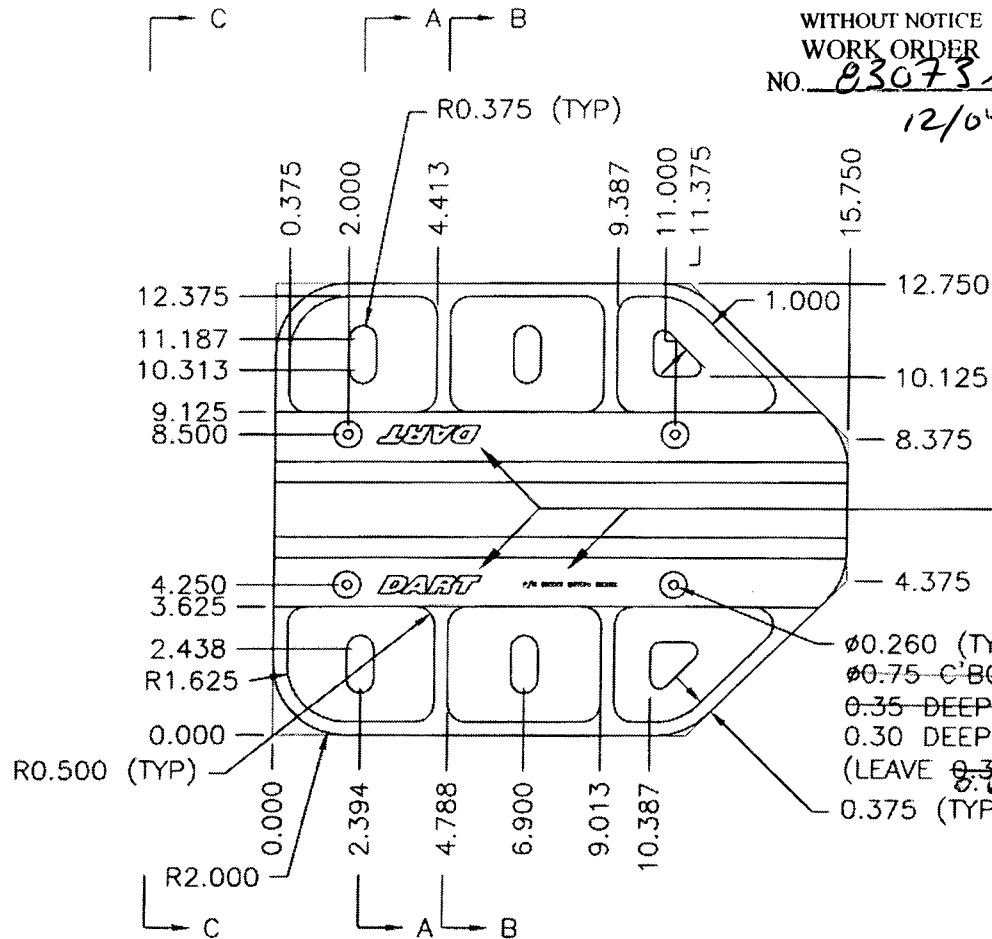
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83073 MCT

12/04/13

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

RELEASED
98.06.17 KE

EFFECTIVE DECS

9143

| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|-------------------|--------------------------------|-----------------------------|
| CHECKED <i>KE</i> | APPROVED <i>KE</i> | HAWKESBURY, ONTARIO, CANADA |
| DATE 98.05.19 | D2671 | REV. B |
| A | 97.04.08 | SHEET 1 OF 2 |
| B | 98.05.19 | SCALE 1:5 |
| | NEW ISSUE | |
| | CHANGE C'BORE, R1.58 WAS R1.50 | |
| | BEARPAW | |

DART



| W/O: | | WORK ORDER CHANGES | | | | | |
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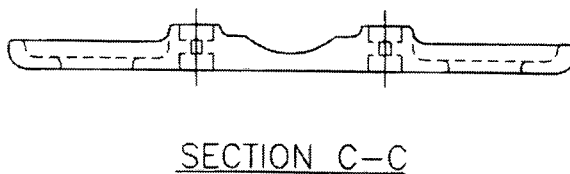
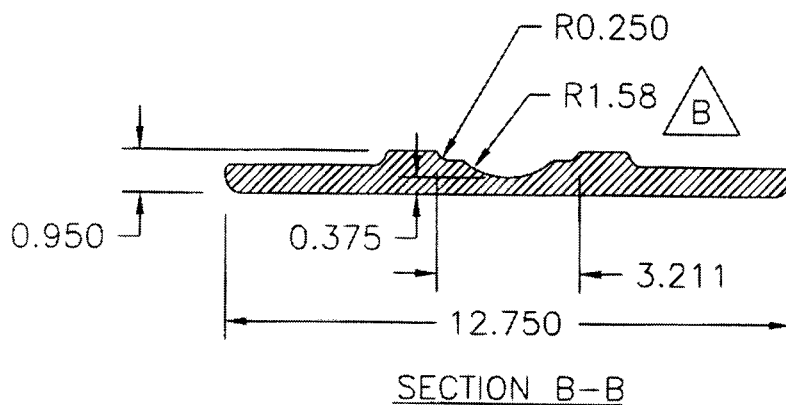
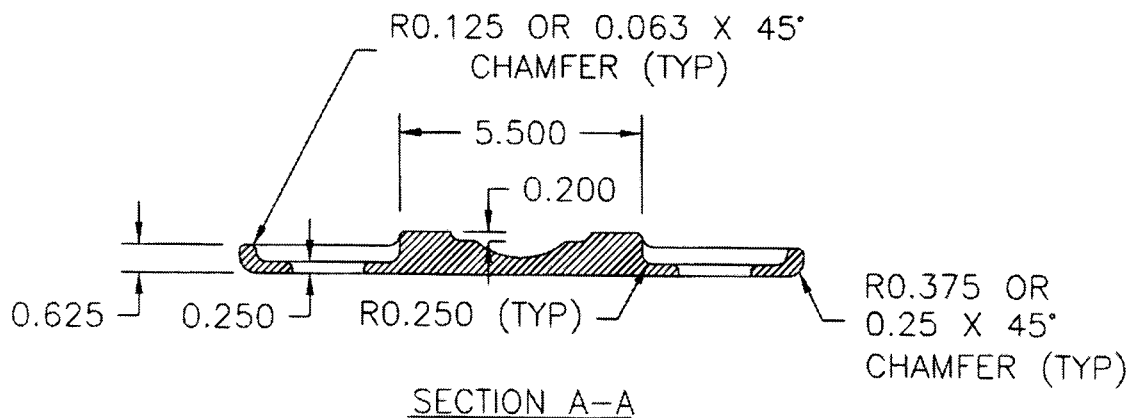
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NOTE: Date & initial all entries



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|----------------------|-----------------------|---|------------------------|
| DESIGN <i>KE</i> | DRAWN BY <i>KE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>DW</i> | APPROVED <i>JS</i> | DRAWING NO. D2671 | REV. B SHEET 2 OF 2 |
| DATE 98.05.19 | | TITLE BEARPAW | SCALE 1:4 |

RELEASED
98.06.17 KE



83073

Dart Aerospace Ltd

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